

Work Order ID 59212

Friday, May 28, 2010 9:22:55 AM



Page 1

Item ID: D350-607-241

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Clamp Assembly

Start Date: 5/27/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-28 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-607-1

A

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D350-607-241
CHG001

8/10/06/30

HJ for BG 10/06/29

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-6-29 60

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

8/10/06/30

x10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59212

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Item ID: D350-607-241

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Start Date: 5/27/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-241

Location:

PPP rev: 12/10/1010/6/30 6

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/30 MFMF 10-6-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 28, 2010 9:22:59 AM

Page 1

Work Order ID: 59212

Parent Item: D350-607-241

Parent Item Name: Basket Clamp Assembly

Comments: IPP RevA: New issue DD verified by:EC
per ECN10-545 DD 10.04.16 verified by:EC



IPP Rev:B as

Start Date: 5/27/2010



Required Date: 6/4/2010

Start Qty: 6.00



Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1		Manufactured	No			110	Each	105.0000	4	24			
												10-6-09	EQ



Location	Loc Qty	Loc Code
ST476	105	
51566	4	
54755	21	
57828	80	

D2230-3		Manufactured	No			110	Each	73.0000	4	24			
												10-6-09	SP

Location	Loc Qty	Loc Code
ST476	73	
57827	73	

D2324		Manufactured	No			110	Each	5.0000	1	6			
												10-6-09	SP

Location	Loc Qty	Loc Code
ST511	5	
57555	5	

D2732		Manufactured	No			110	f	442.8000	2	12			
												10-6-09	SP

Location	Loc Qty	Loc Code
ST412	442.8	
56516	442.8	

1- cut qty (8) 3.00" long per dwg D2732-030

measured
8/10/09/130

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 28, 2010 9:22:59 AM

Page 2

Work Order ID: 59212

Parent Item: D350-607-241

Parent Item Name: Basket Clamp Assembly

Comments: IPP RevA: New issue DD verified by:EC
per ECN10-545 DD 10.04.16 verified by:EC

IPP Rev:B as

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-12A

Purchased

No

110

Each

240.0000

8

48

10-6-29

48

10-6-29

Bolt

Location

Loc Qty

Loc Code

ST357

240

112314

237

11925

3

Purchased

No

110

Each

503.0000

8

48 72

10-6-29

Plb →

AN4-15A

Bolt

Location

Loc Qty

Loc Code

ST358

503

114239

22

114292

181

114615

100

114784

200

Purchased

No

110

Each

1,922.000

26

1156

1115800 10-6-29

NAS1149D0463J

Washer

Location

Loc Qty

Loc Code

ST298

1922

114576

1522

114742

400

Friday, May 28, 2010 9:22:59 AM

Shop Packet Print

Page 2

W/O: <u>59212</u> <u>PERM CHANGE</u>		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/6/88	# 100	Qty x8 is incorrect should be Qty x12	<i>[Signature]</i>	10.06.88			<i>[Signature]</i> 10/6/88

Part No: D350-607-241 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 28, 2010 9:22:59 AM

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Work Order ID: 59212



Parent Item: D350-607-241



Parent Item Name: Basket Clamp Assembly

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP RevA: New issue DD verified by:EC
per ECN10-545 DD 10.04.16 verified by:EC

IPP Rev:B as

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			110	Each	4,601.000	13	78			
											10.6.29	SP	60

546 Nut

Location	Loc Qty	Loc Code
ST139	2	
111827	2	
ST300	4599	
113422	76	
114523	1515	
114718	1000	78
114784	2000	
9063	8	

Friday, May 28, 2010 9:22:59 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST

6.1 D350-607-041/-041A/-043/-043A HELI-UTILITY-BASKET™

Qty -041	Qty -041A	Qty -043	Qty -043A	Qty -241	Part Number	Description
X					D350-607-041	HELI-UTILITY-BASKET
	X				D350-607-041A	HELI-UTILITY-BASKET
		X			D350-607-043	HELI-UTILITY-BASKET
			X		D350-607-043A	HELI-UTILITY-BASKET
1	1	1	1	X	D350-607-241	BASKET CLAMP KIT INSTALLATION
2	2	5	5		D2022-101	SPACER
1	1	1	1		D2221	BASKET BASE ASSEMBLY
				4	D2230-1	LUG
				4	D2230-3	CLAMP
1	1	1	1		D2258-200	LABEL
1	1	1	1		D2324	STRUT
1		1			D2332-041	PROP ASSEMBLY
1	1				D2512	BASKET LID ASSEMBLY
1	1	1	1		D2530	HANDLE WELDMENT
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D2732-030	RUBBER CUSHION
2	2	2	2		D2931	BUMPER
		1	1		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
		1	1		D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1				D350-607-141	AUTOMATIC LID OPENER INSTL
			1		D350-607-143	AUTOMATIC LID OPENER INSTL
2	2	2	2		AN3-16A	BOLT
2	2				AN4-7A	BOLT
5	5	5	5		AN4-12A	BOLT
		2	2		AN4-13A	BOLT
				8	AN4-15A	BOLT
1		7	5		AN4-22A	BOLT
1					AN4-24A	BOLT
4	4	4	4		AN5-17A	BOLT
2	2	2	2		MS20600AD4W3	RIVET (OR CR9163-4-3)
12	12	24	24	16	NAS1149D0463J	WASHER (OR AN960JD416)
2		2			NAS1149D0416J	WASHER (OR AN960JD416L)
4	4	4	4		NAS1149D0563J	WASHER (OR AN960JD516)
2	2	2	2		NAS1149DN832J	WASHER (AN960JD8)
		2	2		NAS1515H4	WASHER
4		4			AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
9	7	14	12	8	MS21042L4	NUT (OR MS21042-4)
4	4	4	4		MS21042L5	NUT (OR MS21042-5)

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Revision: A

Date: 10.03.10

REFERENCE ONLY

6.2 D350-607-045/-045A/-047/-047A HELI-UTILITY-BASKET™

Qty -045	Qty -045A	Qty -047	Qty -047A	Qty -241	Part Number	Description
X					D350-607-045	HELI-UTILITY-BASKET
	X				D350-607-045A	HELI-UTILITY-BASKET
		X			D350-607-047	HELI-UTILITY-BASKET
			X		D350-607-047A	HELI-UTILITY-BASKET
1	1	1	1	X	D350-607-241	BASKET CLAMP KIT INSTALLATION
2	2	5	5		D2022-101	SPACER
				4	D2230-1	LUG
				4	D2230-3	CLAMP
1	1	1	1		D2258-200	LABEL
1	1	1	1		D2324	STRUT
1		1			D2332-041	PROP ASSEMBLY
1	1	1	1		D2530	HANDLE WELDMENT
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D2732-030	RUBBER CUSHION
2	2	2	2		D2931	BUMPER
1	1	1	1		D3265-041	BASKET BASE ASSEMBLY
1	1				D3266-041	BASKET LID ASSEMBLY
		1	1		D3267-041	BASKET LID (OUTSIDE)
		1	1		D3267-043	BASKET LID (INSIDE)
			1		D350-607-143	AUTOMATIC LID OPENER INSTL
	1				D350-607-145	AUTOMATIC LID OPENER INSTL
2	2	2	2		AN3-16A	BOLT
2	2				AN4-7A	BOLT
5	5	5	5		AN4-12A	BOLT
		2	2		AN4-13A	BOLT
				8	AN4-15A	BOLT
1		7	5		AN4-22A	BOLT
1					AN4-24A	BOLT
4	4	4	4		AN5-17A	BOLT
2	2	2	2		MS20600AD4W3	RIVET (OR CR9163-4-3)
12	12	24	24	16	NAS1149D0463J	WASHER (OR AN960JD416)
2		2			NAS1149D0416J	WASHER (OR AN960JD416L)
4	4	4	4		NAS1149D0563J	WASHER (OR AN960JD516)
2	2	2	2		NAS1149DN832J	WASHER (AN960JD8)
		2	2		NAS1515H4	WASHER
4		4			AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
9	7	14	12	8	MS21042L4	NUT (OR MS21042-4)
4	4	4	4		MS21042L5	NUT (OR MS21042-5)

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Revision: A
 Date: 10.03.10

REFERENCE ONLY

FOR D350-607-041 AT CHG 008, D350-607-043 AT CHG 005, AND D350-607-045/-047 AT CHG 003 AND SUBSEQUENT, THE INTENT OF DSI 9342 HAS BEEN INCORPORATED DURING MANUFACTURE. AMEND WEIGHT AND BALANCE AS OUTLINED BELOW. ALSO, THE PARTS LIST HAS BEEN AMENDED AS FOLLOWS:

QTY. -041	QTY. -043	QTY. -045	QTY. -047	PART NUMBER	DESCRIPTION
X				D350-607-041	HELI-UTILITY BASKET
	X			D350-607-043	HELI-UTILITY BASKET
		X		D350-607-045	HELI-UTILITY BASKET (SHORT)
			X	D350-607-047	HELI-UTILITY BASKET (SHORT)

IS:

1	1	1	1	AN4-12A	BOLT
4	4	4	4	AN4-15A	BOLT
28	40	30*	42*	AN960JD416	WASHER

*: EXTRA WASHERS REQUIRED TO MOUNT LID ON BASE DUE TO INCREASED THICKNESS OF GUSSETS AT BOTH ENDS OF BASKET BASE. LOCATE WASHERS BETWEEN BASE HINGE PLATE AND D2022-101 SPACER, TYPICAL BOTH ENDS.

WAS:

5	5	5	5	AN4-12A	BOLT
28	40	28	40	AN960JD416	WASHER

WEIGHT & BALANCE






INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D350-607-041/-043 AT CHG 008/005 HELI-UTILITY BASKET	89.6 lb 40.6 kg	±48 in ±1.22 m	±4301 in-lb ±49.5 m-kG	135 in 3.43 m	±12096 in-lb ±139.3 m-kG
D350-607-045/-047 AT CHG 003 HELI-UTILITY BASKET (SHORT)	66.6 lb 30.2 kg	±48 in ±1.22 m	±3197 in-lb ±36.8 m-kG	135 in 3.43 m	±8991 in-lb ±103.6 m-kG

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.04.06
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9342	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE WELD REPAIR	NTS
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